



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW6210G01031-8G
Job Sheet 186078



DAS
21
9-89

Part No: RBW6210G01031-8G

Job Qty: 1 pes

Part Name: M/R Blade Trim Tab Bending Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6210G01031-8G Rev.B IPP Rev. A 18.10.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/14/18		0.00	0.20	Small Fab - 1		
							Small Fab - 2		MCC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	12/14/18		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/14/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S162351



Part: RBW6210G01031-8G

Job No: 186078

Serial No/Batch: S162351

Revision: C

Inspector:

Exp Date:

Instructions:

Date: 03/14/19

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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	12/14/18	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
Part Op 110 - Small Fab-3 (Small Fab) 1-Assemble as per DWG. See note 9 and 10. Descriptions: 120 - QC5 (QC5- Inspect part completeness to step on W/O) 130 - Packaging3-1 (Identify as per dwg & Stock Location: _____) The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG. 140 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
93585A190	SS Knurled Thumb Screw 1/4"-20 x 3/4" Long	4 Ea (4 ea)	110-Small Fab - 1	110472	
RBW6210G01031-8G-1	Lower Plate Assembly	1 pcs (1 ea)	110-Small Fab - 1	5157308	
RBW6210G01031-8G-3	Upper Plate	1 pcs (1 ea)	110-Small Fab - 1	51355818	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	93585A190	4	5	0	
	RBW6210G01031-8G-1	1	0	0	
	RBW6210G01031-8G-3	1	6	0	
Part Specifications					
Specifications could not be found.					



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Job Sheet 186078



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Part Name: M/R Blade Trim Tab Bending Tool



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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/14/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		12/14/18	0.00	0.20	Small Fab-3		
120	QC	1 pcs		12/14/18	0.00	0.00	QC5		
130	Packaging	1 pcs		12/14/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		12/14/18	0.00	0.00	QC21		

Part Op 110 - 1-Assemble as per DWG. See note 9 and 10.

Descriptions: 130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
93585A190	SS Knurled Thumb Screw 1/4"-20 x 3/4" Long	4 Ea (4 ea)	90-Start up Operation	
RBW6210G01031-8G-1	Lower Plate Assembly	1 Ea (1 ea)	90-Start up Operation	
RBW6210G01031-8G-3	Upper Plate	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	93585A190	4	5	0
	RBW6210G01031-8G-1	1	0	0
	RBW6210G01031-8G-3	1	0	0

Part Specifications

Specifications could not be found.

Plex 11/9/18 1:19 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



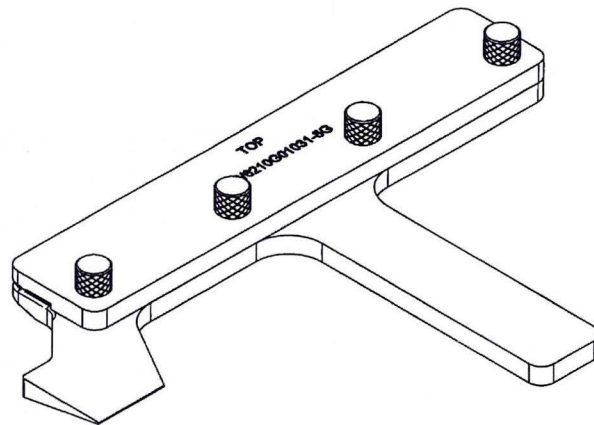
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

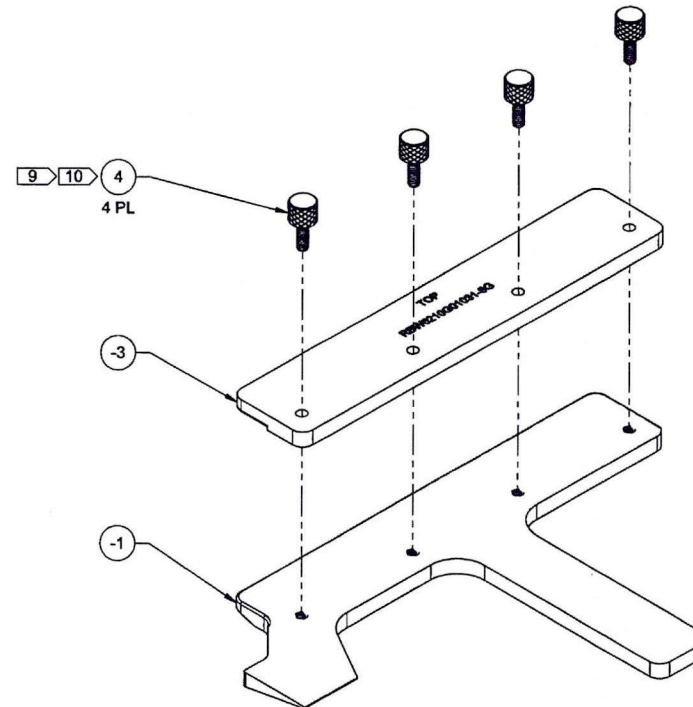
ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6210G01031-8G-1	LOWER PLATE ASSY
-3	1	RBW6210G01031-8G-3	UPPER PLATE
4	4	McMaster#93585A190 OR EQUIV.	SS KNURLED THUMB SCREW 1/4"-20 X 3/4" LG.



RBW6210G01031-8G M/R BLADE TRIM TAB BENDING TOOL

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY LOCTITE NICKEL BASED ANTI SEIZE ON THREADS OF ITEM 4 THEN ASSEMBLE WITH ITEM -1
- 10) INSTALL ITEM 4 HAND TIGHT
- 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186078
ML5
1871-14

B	-2, -3 R0.05 ADDED ALONG THE EDGE	18-812	KPT
A	NEW ISSUE		KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBW6210G01031-8G	SHEET 1 OF 4
APPROVED	VF	TITLE	SCALE
		M/R BLADE TRIM TAB BENDING TOOL	NTS
DATE	9/24/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	